

Work Order ID 81308

81308

Page 1

March-12-12 4:45:11 PM

Item ID: D3065-5 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Leg
 Start Date: 12/03/2012 Start Qty: 80.00 ***80*** Cust Item ID:
 Required Date: 26/03/2012 Req'd Qty: 80.00 ***80*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/13 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3065	Rev B								

100 0.00
100 FLOW WATER JET
 Waterjet Memo 0.00 B12-3-24
 FLOW CNC Waterjet 1-Cut as per Dwg D Dwg Rev: B Prog Rev: B 2-Deburr
6061 . 080 if necessary

110 0.00
110 QC2- Inspect parts off machine FAI/FAIB
 QC Memo 0.00 B12-3-24
 Quality Control

120 0.00
120 QC8- Inspect parts - second check
 QC Memo 0.00 5263127
 Quality Control as per

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130									
HandFinish	Memo	0.00							
Hand Finishing									
140	QC3- Inspect Part Finish	0.00							
140									
QC	Memo	0.00							
Quality Control									
150	Identify as per dwg & Stock Location: <i>GA</i>	0.00							
150									
Packaging	Memo	0.00							
Packaging									

80X ✓ M/L 12/03/27

to 12-3-27

EP 12/03/29 (80)

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Item ID: D3065-5

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Step Leg

Start Date: 12/03/2012 Start Qty: 80.00

80

Cust Item ID:

Required Date: 26/03/2012 Req'd Qty: 80.00

80

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

12/3/3008

12-03-29

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Picklist Print

March-12-12 4:45:15 PM

Page 1

Work Order ID: 81308

81308

Parent Item: D3065-5

D3065-5

Parent Item Name: Step Leg

Start Date: 12/03/2012

Required Date: 26/03/2012

Start Qty: 80.00

Required Qty: 80.00

Comments:

IPP: C02.11.01Incorporated D3066-1 IPPKJ/RF

IPP Rev:D Now on Water Jet 06-04-11 JLM

IPP Rev:E Now manufactured with 6061-T6 06-05-25 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased	No			100	sf	157.7000	0.825	69.47368	69.47368		
M6061T6S 080									**				
6061-T6 .080 Sheet													

Location

MAT021

Loc Qty

157.7

117285

3.8

119766

40

120349

113.9

121096

Loc Code

120349 x 40

121096 x 40

B12-3-24

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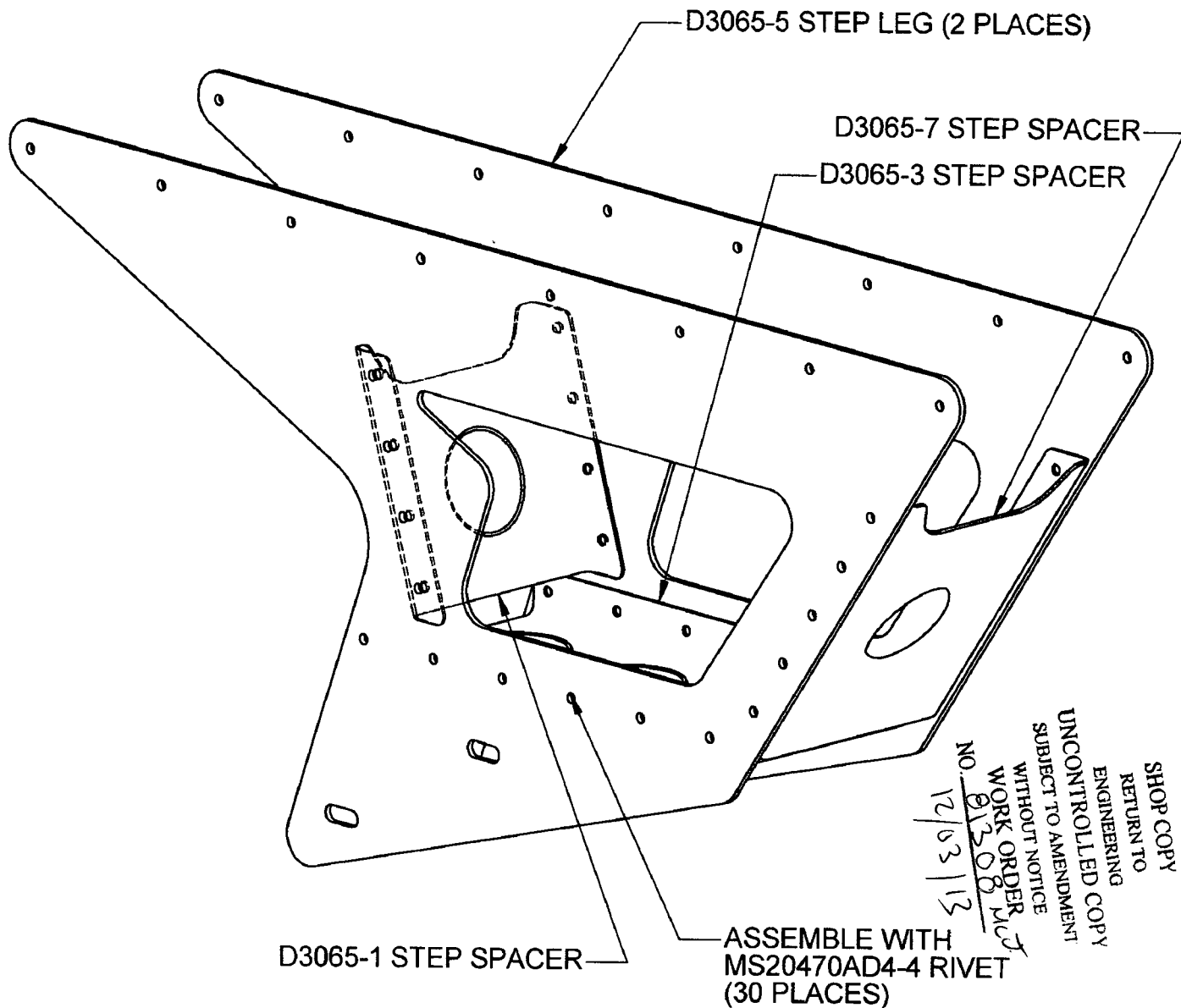
NOTE: Date & initial all entries

DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B2 SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED

06-06-20 *[Signature]*



D3065-041 STEP LEG ASSEMBLY

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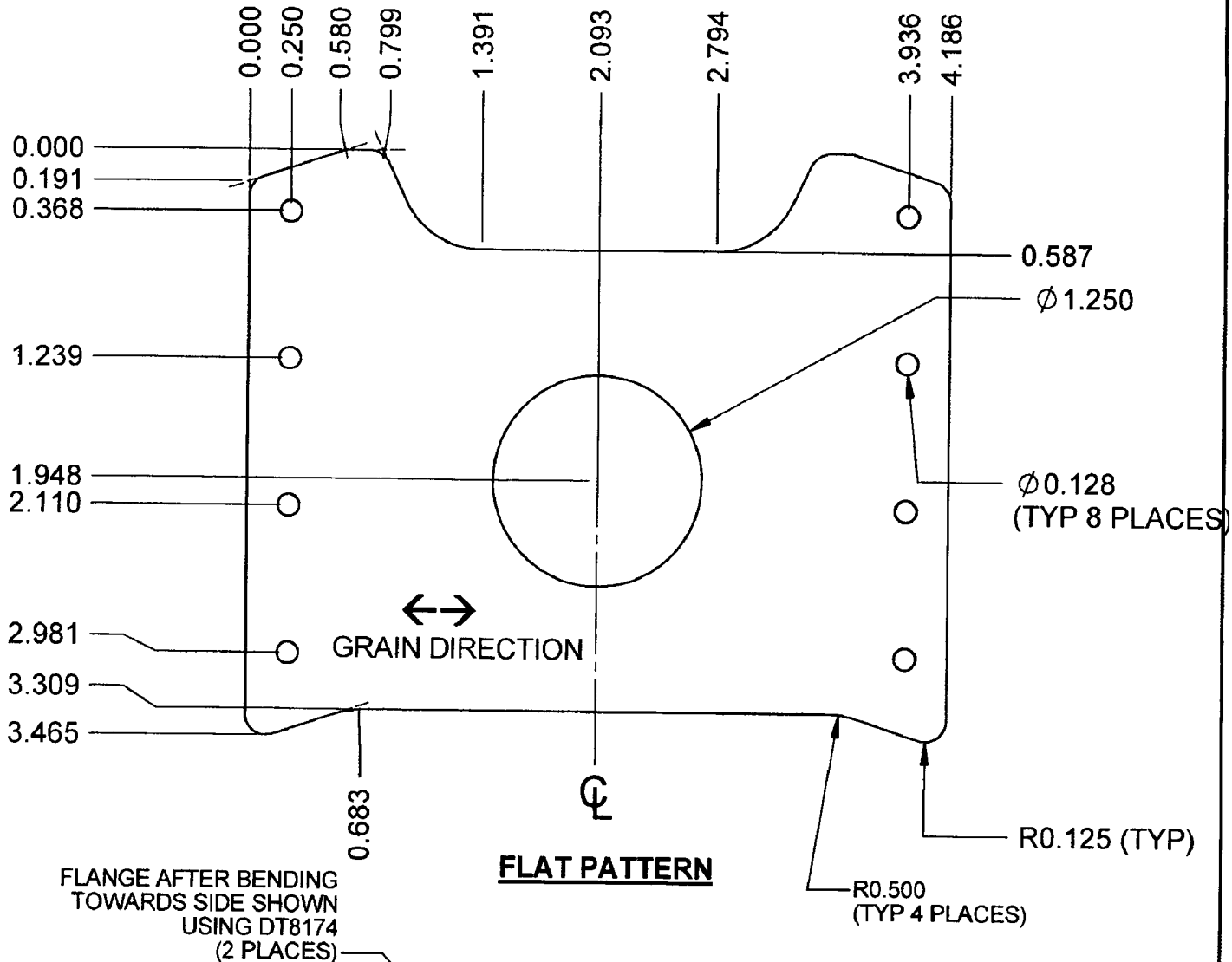
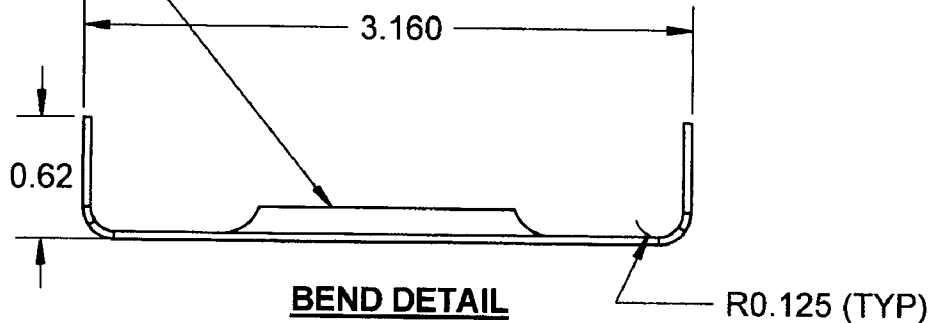
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CHECKED <i>PH</i>	APPROVED <i>HA</i>	DRAWING NO. D3065	REV. B SHEET 2 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

**RELEASED***CP CB HA***D3065-1 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

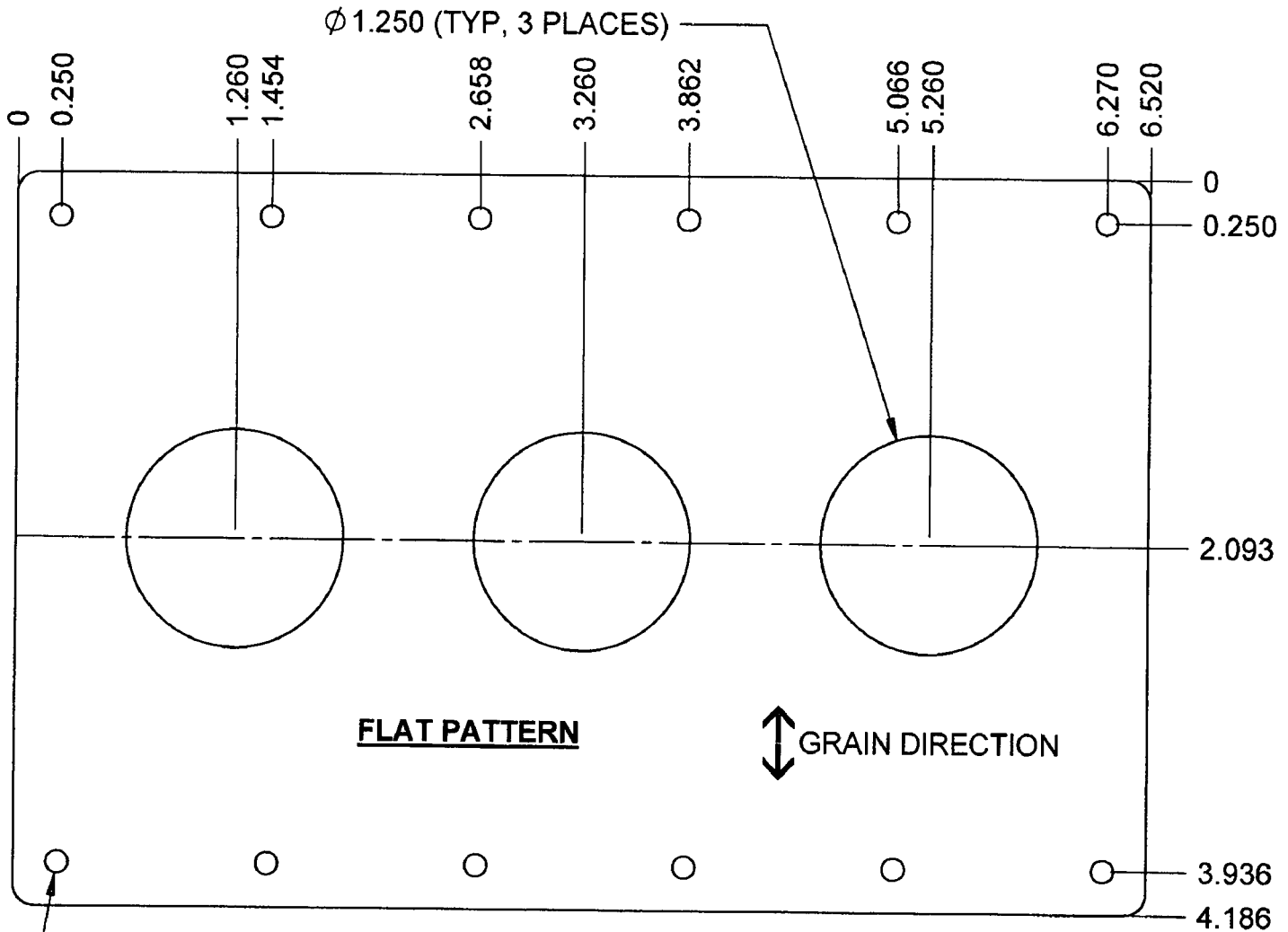
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DART

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 3 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

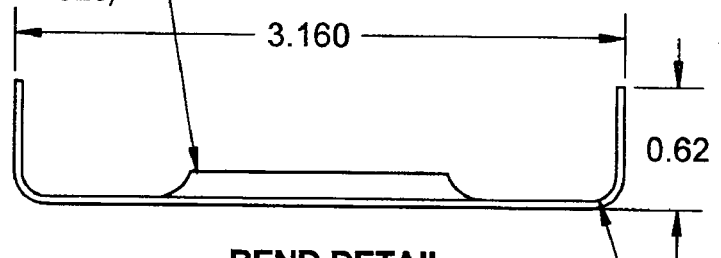


FLANGE AFTER TOWARDS SIDE
SHOWN USING DT8174 (3 PLACES)

0.129 (TYP, 12 PLACES)

RELEASED

06.05.23 *[Signature]*



BEND DETAIL

R0.125

8.1308

D3065-3 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWN BY

APPROVED

1

TITLE
STEP LEG ASSEMBLY

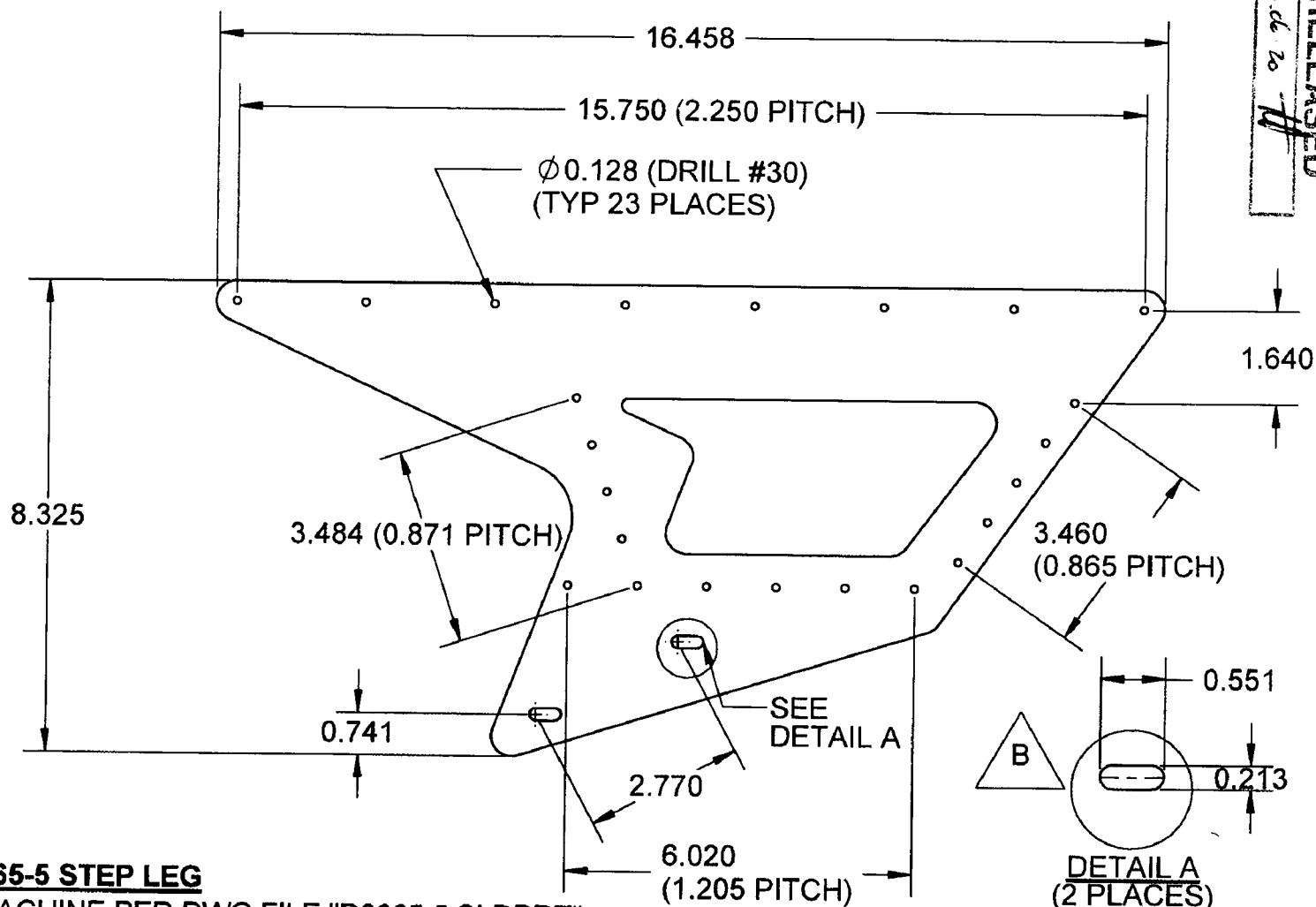
REV. B
T 4 OF 5
SCALE

SHEET 4 OF 5

SCALE

SCALE
1:3

RELEASED
Dec 20 11



1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
 (REF DART SPEC M6061T6S.080)
 OR
 5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 6) ALL DIMENSIONS ARE IN INCHES

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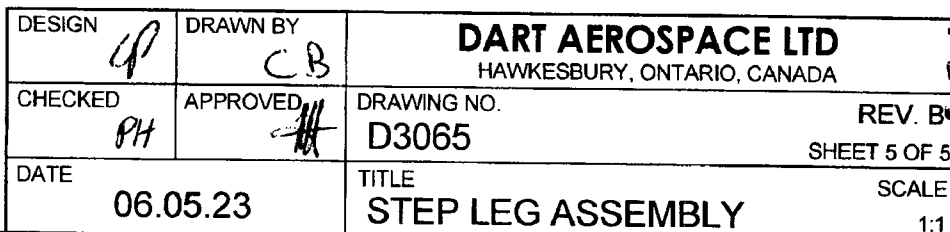
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- 8/308

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